

Date: Thursday, 10/11/2007 2:54:02 PM
User: Kim Johnston

Process Sheet

Wong

Customer: CU-DAR001 Dart Helicopters Services
Job Number: 35116-2
Estimate Number: 10956
P.O. Number: N/A
This Issue: 10/11/2007 S.O. No.: NA
Prsht Rev.: NC
First Issue: N/A Type: SMALL / MED FAB
Previous Run: 31244
Written By: [Signature]
Checked & Approved By: [Signature] 07.10.11
Comment: Est. D 01.06.04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21EC

Drawing Name: STRUT
Part Number: D2565203
Drawing Number: D2565 REV E
Project Number: N/A
Drawing Revision: E
Material: N/A
Due Date: 10/17/2007 Qty: 10 Jns: Each

Additional Product

Job Number:



Seq. # Machine Or Operation: Description:

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty: 1.8375 f(s)/Unit Total: 18.3750 f(s)
Material: 304/316 SS tubing 0.750" Dia x 0.049" wall
(M304TR0750W049) Batch No: M105732

2.0 BRAKE NC NC BRAKE



Comment: BRAKE NC
Punch as per Dwg D2565 using DT 8313

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Drill hole as per Dwg D2565 (one end only)
Deburr

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

M105068 m.f. 07/10/18

6 struts

PTO

6X

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Customer: CU-DARC01 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 35116

Part Number: D2565203

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

607/10/18

(6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *51270*

607/10/18

(6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

607/10/18

Job Completion:

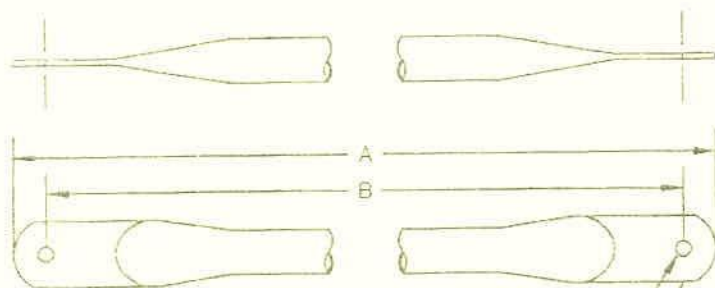


607/10/18



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT SCALE	
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04 05 05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA
D2565-101	20.52	19.72	0.3
D2565-103	18.21	17.41	0.3
D2565-105	20.19	19.39	0.3
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.3
D2565-203	20.75	19.95	0.3
D2565-205	21.22	20.42	0.3
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.3
D2565-303	25.34	24.54	0.3
D2565-305	23.73	22.93	0.3
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.3
D2565-403	15.64	14.84	0.3
D2565-405	19.45	18.65	0.3
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL

(REF DART SPEC. M304TR0.750W0.049)

ENSURE SEAMLESS TUBE IS USED

2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

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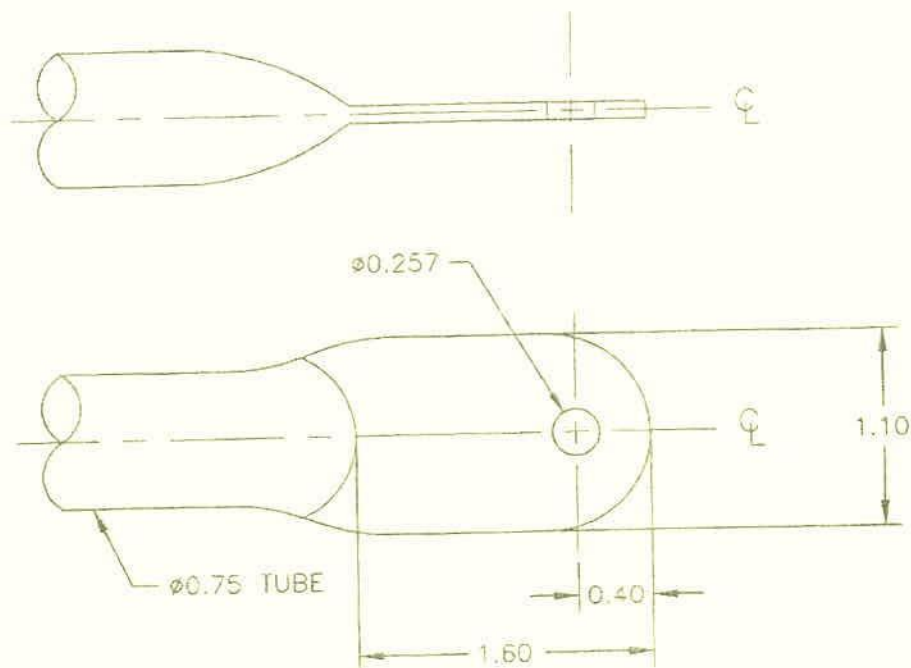
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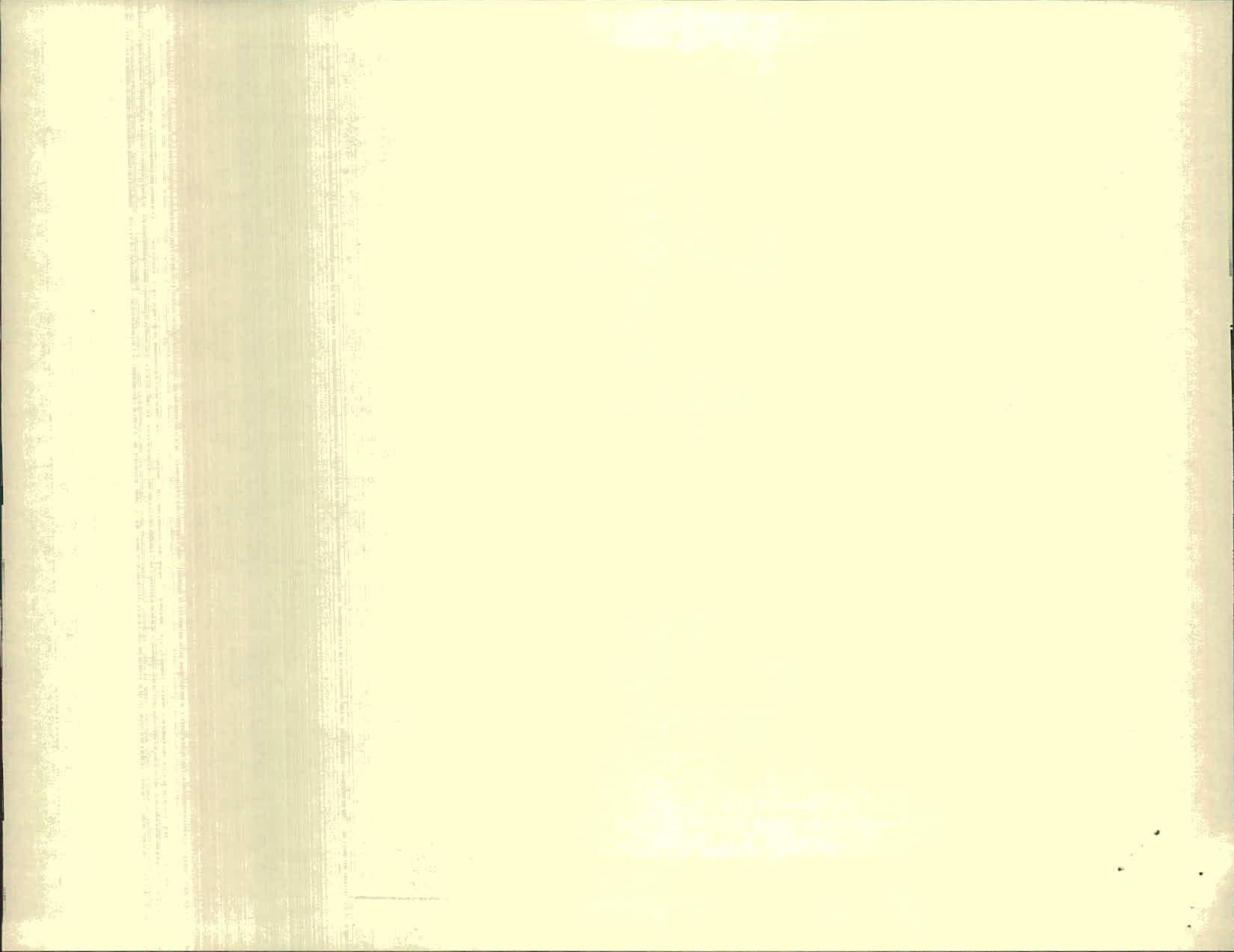
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CHECKED <i>DM</i>	APPROVED <i>KE</i>	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
14/01/09 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117




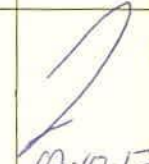
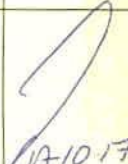
UNCONTROLLED
SUBJECT TO
REVISION
NO. 35116



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10-17	5.0	Manufacture material identification, was not removed completely on 6 struts. Mat'l <u>WAS</u> cleaned. R.C. Markings embedded into the material.	 QSI/012	Buff off all ink markings on struts, and scuff P.C. - Re-powder coat white per QSI 005			 07-10-17	 07-10-17

NOTE: Date & initial all entries

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